

BHEL		STANDARD MANUFACTURING QUALITY PLAN							MQP. NO.: SMQP/FPS/15/092013				
PROJECT ENGINEERING & SYSTEMS DIVISION BHEL, RC PURAM, HYD-502032						PRODUCT: STRAINER			REV NO: 00		DATE: 01/09/2013		
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SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	*	AGENCY			REMARKS
									D	P	W	V	
1.0	RAW MATERIALS & BOUGHT OUT ITEMS												
	Body, Cover	Mechanical & Chemical Properties	Major	Mech., Chem. Analysis	One per lot	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	MTC	√	2		1	
		Non Destructive Examination	Major	NDT Test	100%	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2		1	
	Screen	Chemical Properties, Degree of Filtration	Major	Chem. Analysis, Measure ment	One Sample	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	MTC, TC	√	2		1	
	Gasket, Drain Plug, Fasteners	Mechanical & Chemical Properties	Major	Mech., Chem. Analysis	One per Lot	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	MTC	√	2		1	
2.0	INPROCESS INSPECTION												
		Manufacturing processes	Major	Process Controls	Each lot	BHEL Spec/ Vendor's Own process	BHEL Spec/ Vendor's Own process	--	-	2	2		
3.0	FINAL INSPECTION & TESTING												
	Strainer Assy.	Dimensional	Major	Measure ment	As per IS:2500	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2	1		
		Hydrostatic Test	Critical	Hydro Test	100%	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2	1		
LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL / BHEL NOMINATED INSPECTION AGENCY/END USER/END USER'S REPRESENTATIVE & 2 FOR VENDOR/SUB VENDOR AS APPROPRIATE AGAINST EACH COMPONENT /CHARACTERISTIC UNDER P, W & V COLUMNS. * FOR ITEMS MARKED ✓ (TICK) IN COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.						PREPARED BY BHEL QA		APPROVED BY BHEL QA S		APPROVED BY CUSTOMER'S SIGNATURE & STAMP (IF APPLICABLE)			

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										P	W	V	
		PMI Check	Critical	PMI	10%	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2	1		
		NDT TEST	Critical	NDT	10%	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2		1	
4.0	PRESERVATION & PACKING												
		Painting, Marking (Shade, DFT Check)	Major	Visual, Measure ment	Random	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	TC	√	2	1		
		Packing*	Major	Visual	Random	BHEL Spec/Appd. Dwg/ Datasheet	BHEL Spec/Appd. Dwg/ Datasheet	Packing List	√	2		1	

NOTE:-

1. This standard MQP should be read along with specification (latest revision), approved drawings & approved data sheet.
2. Drawing/data sheet shall prevail over quality plan for contradiction if any between quality plan and drawing/specification.
3. All test certificates/reports reviewed and certified by TPI/BHEL shall be submitted to BHEL as documentation package.
4. All type test reports submitted shall not be older than 5 yrs from the date of purchase order.
5. Any project/customer specific requirements which shall be notified have to be fulfilled by the vendor at the time of execution of order.

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